

* Date: Monday, 04/05/2009 1:45:14 PM
 * User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : VERTICAL TUNNEL AFT CENTER |
| Job Number : 47672C | |
| Estimate Number : 13587 | |
| P.O. Number : | Part Number : D38223 64 |
| This Issue : 04/05/2009 S.O. No. : | Drawing Number : D3822-3 |
| Prsht Rev. : NC | Project Number : |
| First Issue : / / Type : THERMOFORMING | Drawing Revision : B |
| Previous Run : 47304C | Material : MKYD6185S080P362015 |
| Written By : | Due Date : 11/05/2009 Qty: 1 Um: Each |
| Checked & Approved By : <u>JD 09-05-04</u> | 29 |
| Comment : Est. A New Issue 08/09/17 DL Rev B Dwg Update 09/02/09 DL verified by:DD | POSITIVE RECALL |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|----------------------------|
| 1.0 | MKYD6185S080P352068 | 6185 Kydex .080 steel grey |



Comment: Qty.: 5.4170 sf(s)/Unit Total : 5.4170 sf(s)
6185 Kydex .080"

M111807



| | | |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/20

| | | |
|-----|----------------|------------------------------|
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/20 X2 X1

| | | |
|-----|---------------|-----------------------|
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-3 and folio FTA 027 using tool DT 9072

Dwg. Rev. BFolio Rev. B

BB 09/05/21 X2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3822-3GY PAR #: N/A Fault Category: Prod/Thermofarming NCR: (Yes) No DQA: D Date: 09/05/27
D206781-151
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/05/27

| NCR: <u>47672C</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------------|------------|---|-----------------------------|---|---------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>09/05/25</u> | <u>L/O</u> | <u>2 X SCRAP</u> <u>1 X MISTRIMMED</u> <u>1 X MACHINE ERROR</u> | <u>[Signature]</u> | <u>Scrap in ches tray</u> <u>Replace qty 2 per</u> <u>w/o Qty</u> | <u>[Signature]</u> <u>09/05/25</u> | <u>[Signature]</u> <u>090525</u> | <u>[Signature]</u> <u>090525</u> | <u>[Signature]</u> <u>090525</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL AFT CENTER

Job Number: 47672C

Part Number: D38223

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 X 2

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

OK 09.05.21

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

OK 09.05.21

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

OK 09.05.21.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090525(2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PRR 47672

POSITIVE RECALL

EFFECT: 09-05-20 WITH

RELEASE: 09/05/25

FINAL INSPECTION W/O RELEASE

OK

11.0

QC21



Comment: FINAL INSPECTION W/O RELEASE

09/05/26

Job Completion



mk 09-05-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

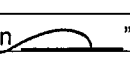
NOTE: Date & initial all entries


| | |
|---------------------------------|----------------------|
| DART AEROSPACE LTD | Work Order: 47672C |
| Description: | Part Number: D3822-3 |
| Inspection Dwg: D3822-3 Rev: 13 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|--|--------|--------|----------------------|----------|
| Inside Radii less than  " N/A | | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: 

Date: 09/05/21

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.40 | MIN. | 0.409 | ✓ | | | |
| 0.50 | MIN. | 0.7 | ✓ | | | |
| 0.06 | MIN. | 0.07 | ✓ | | | |
| 0.035 | MIN. | 0.04 | ✓ | | | |
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Measured by: 

Date: 09.05.21

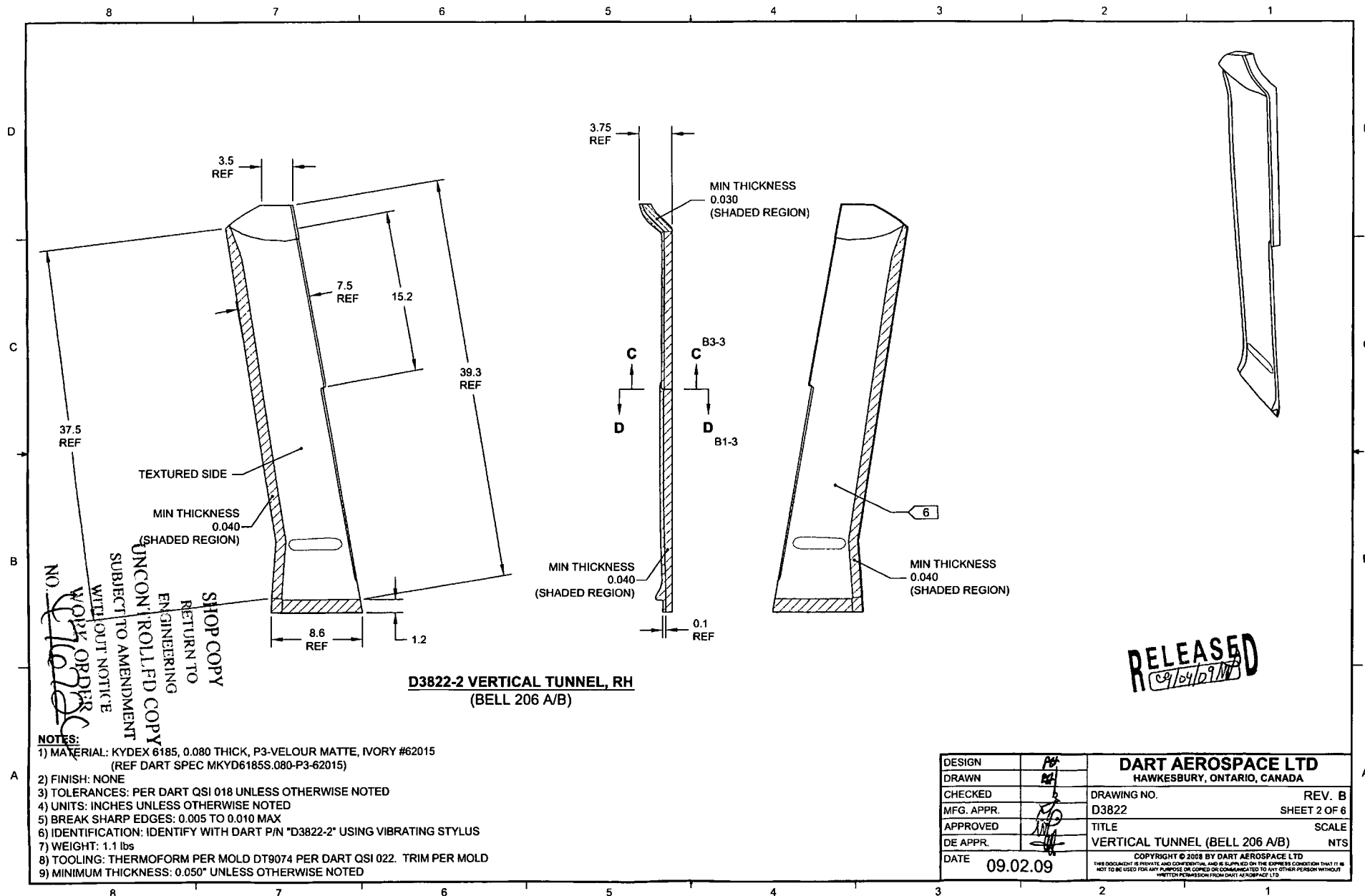
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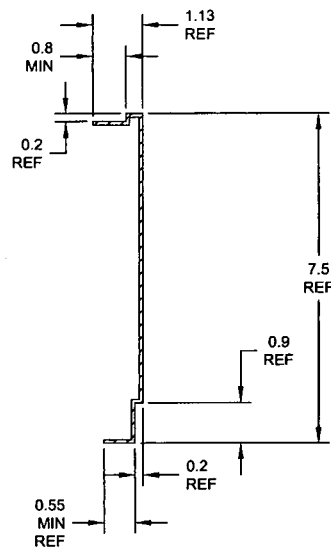
Date: 09.05.21

Prototype Approval: 

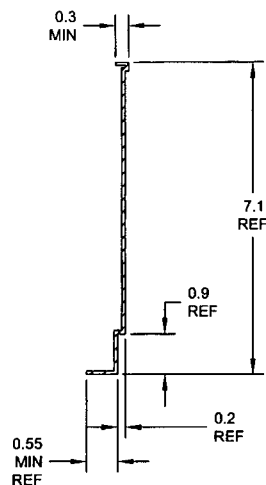
Date:

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |

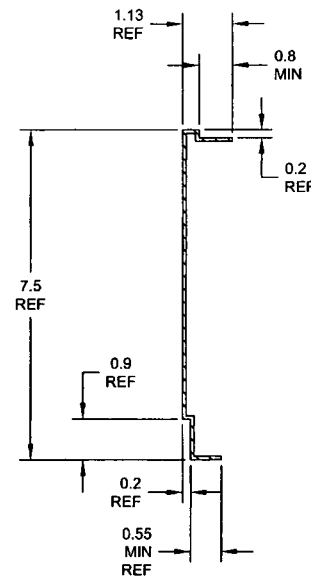




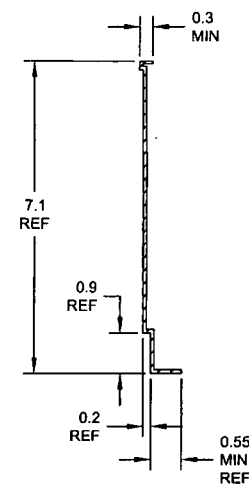
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



SECTION D-D C4-2

RELEASED
Shirley W

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 416072

| | | | |
|------------|-----------|--|--------------|
| DESIGN | <i>PH</i> | DART AEROSPACE LTD | |
| DRAWN | <i>PH</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>PH</i> | D3822 | SHEET 3 OF 6 |
| APPROVED | <i>PH</i> | TITLE | SCALE |
| DE APPR. | <i>PH</i> | VERTICAL TUNNEL (BELL 206 A/B) | NTS |
| DATE | 09.02.09 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

37.8
REF
B

0.3
REF

MIN THICKNESS
0.035
(SHADED REGION,
BOTH SIDES)

2.4
REF

VIEW F
A1-4

VIEW J
A3-4

6.7
REF

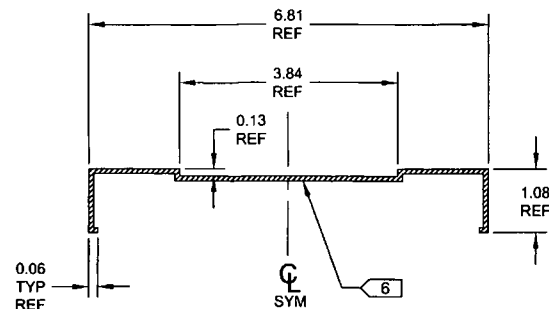
MIN THICKNESS
0.020
(SHADED REGION)

0.5
MIN

C2-4

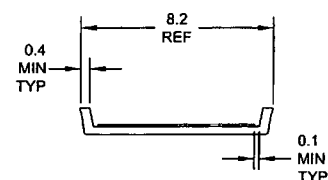
TEXTURED SIDE

CL
SYM

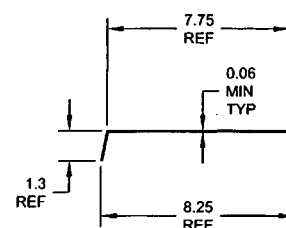


SECTION E-E
SCALE 5X

RELEASED
2/10/18



VIEW J
SCALE 2X
D5-4



VIEW F
SCALE 2X
(ROTATED 90° CW)
B7-4

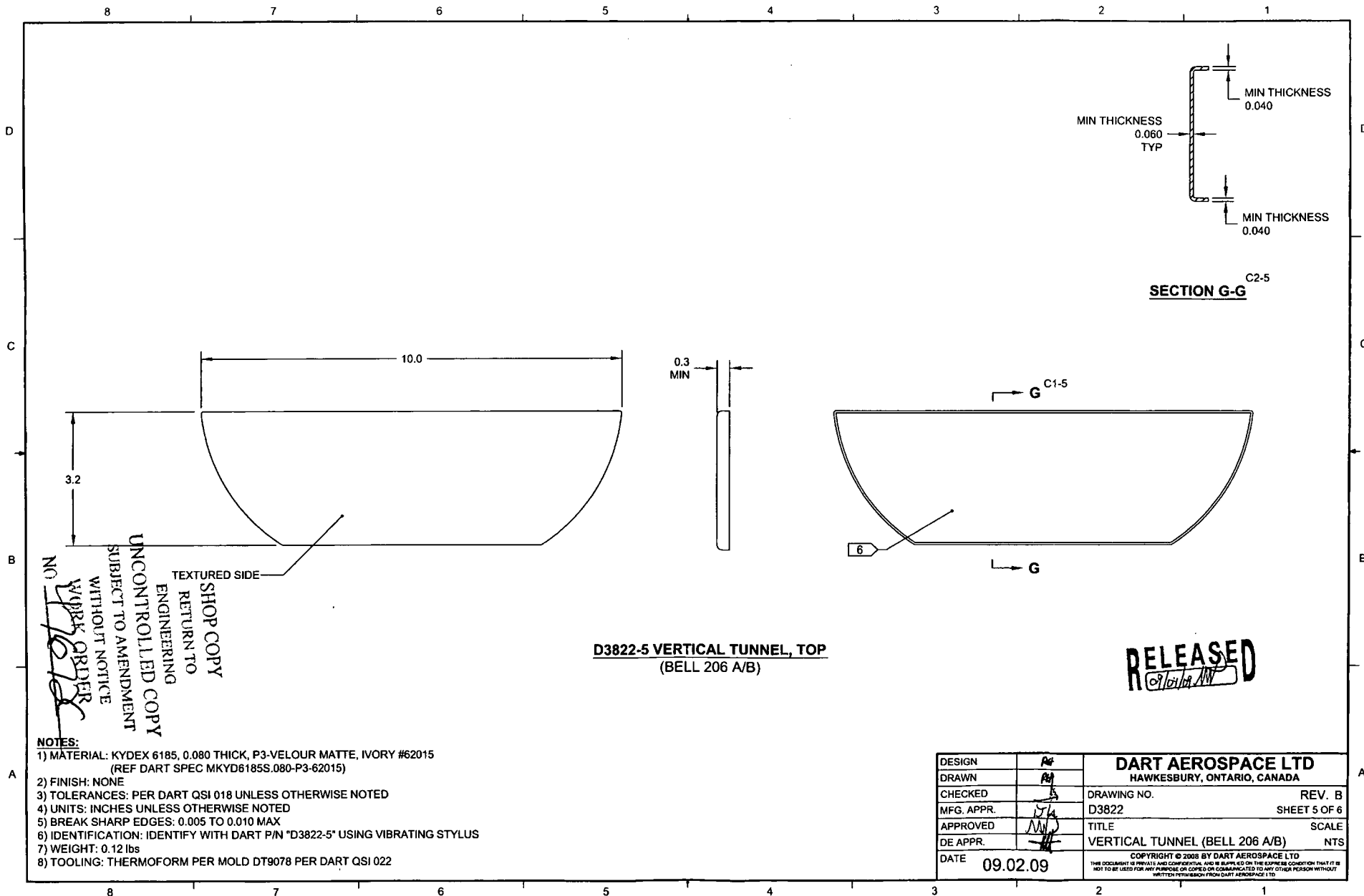
D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

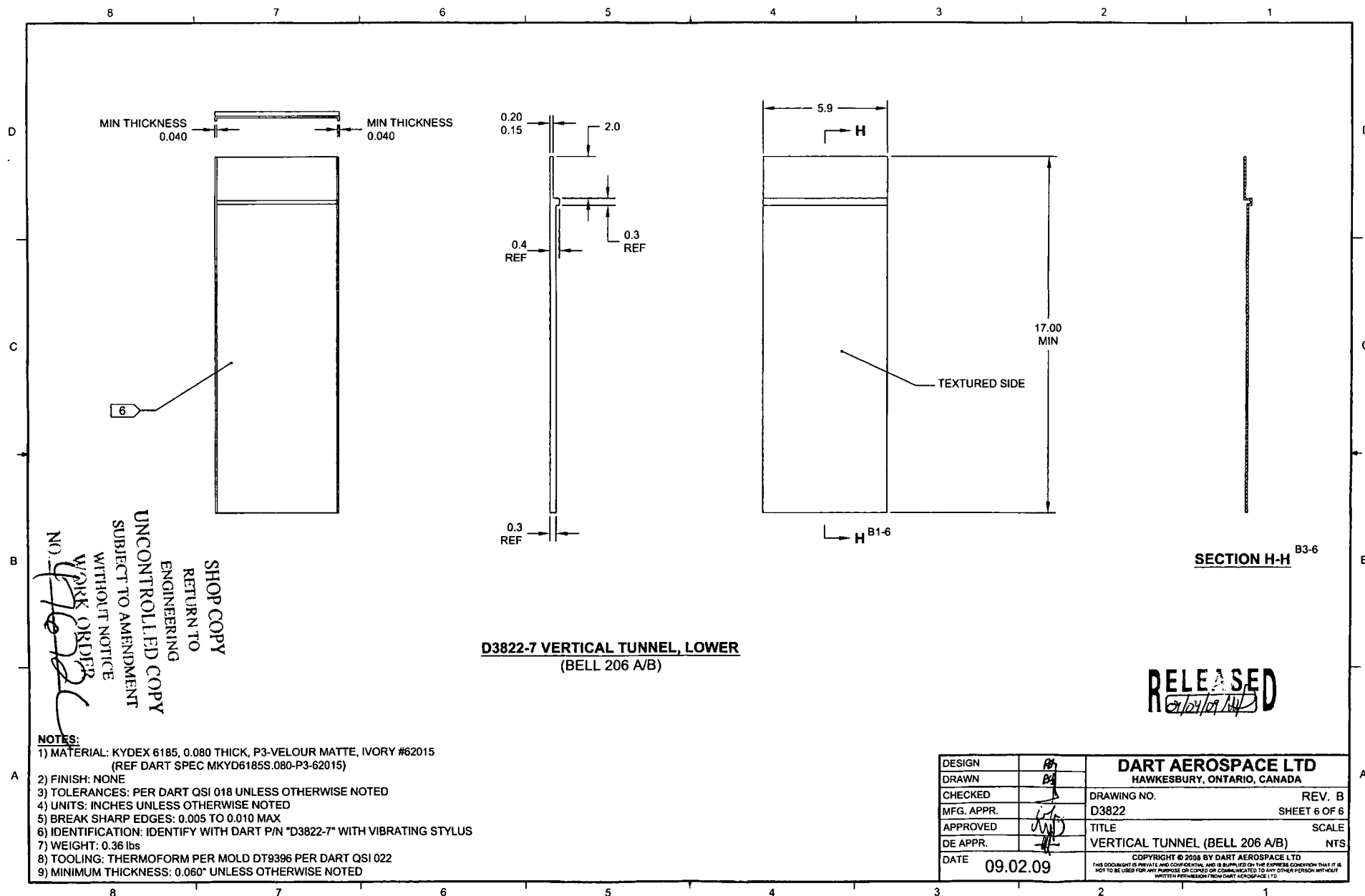
- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

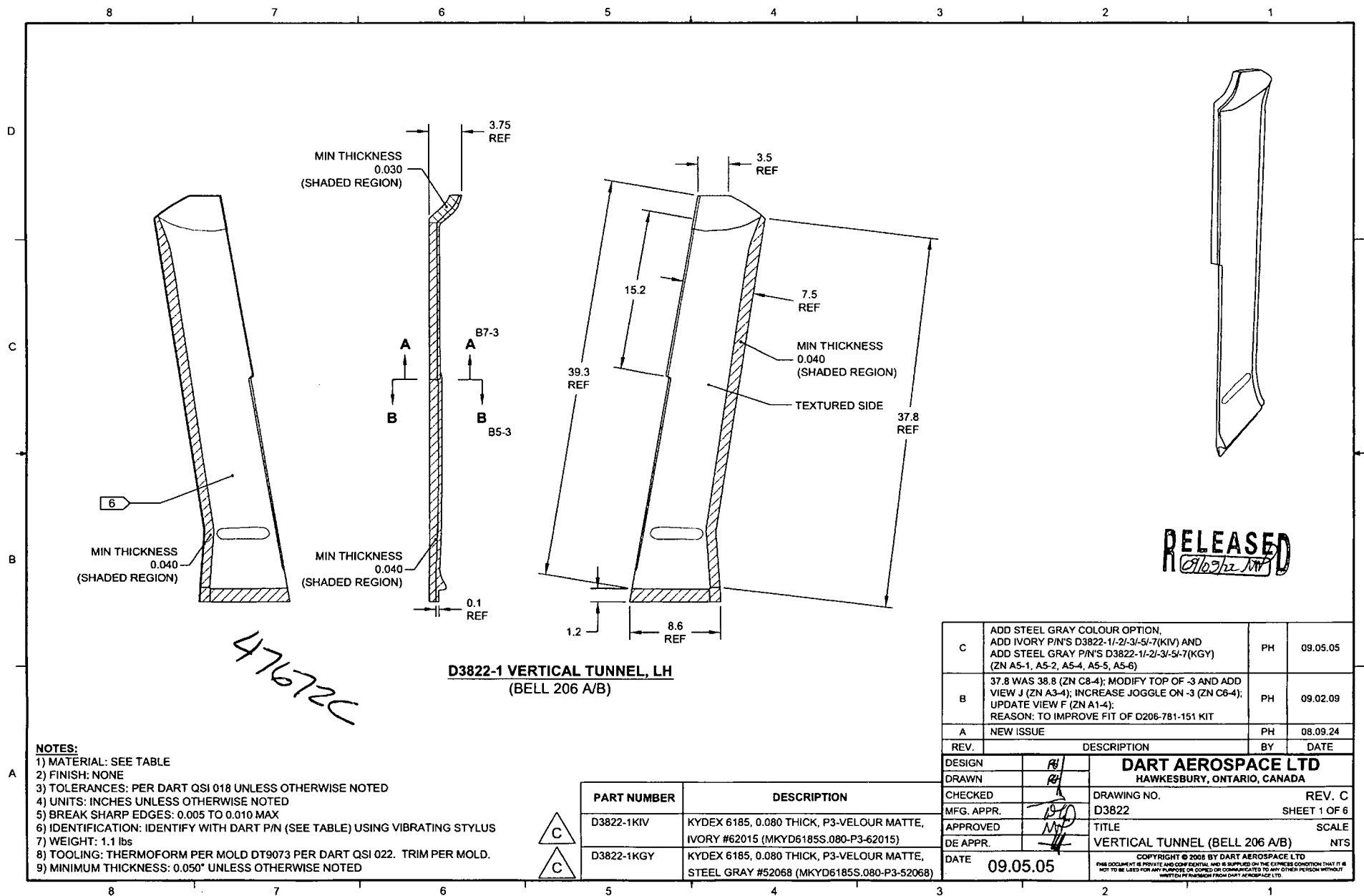
NO. 471618
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT

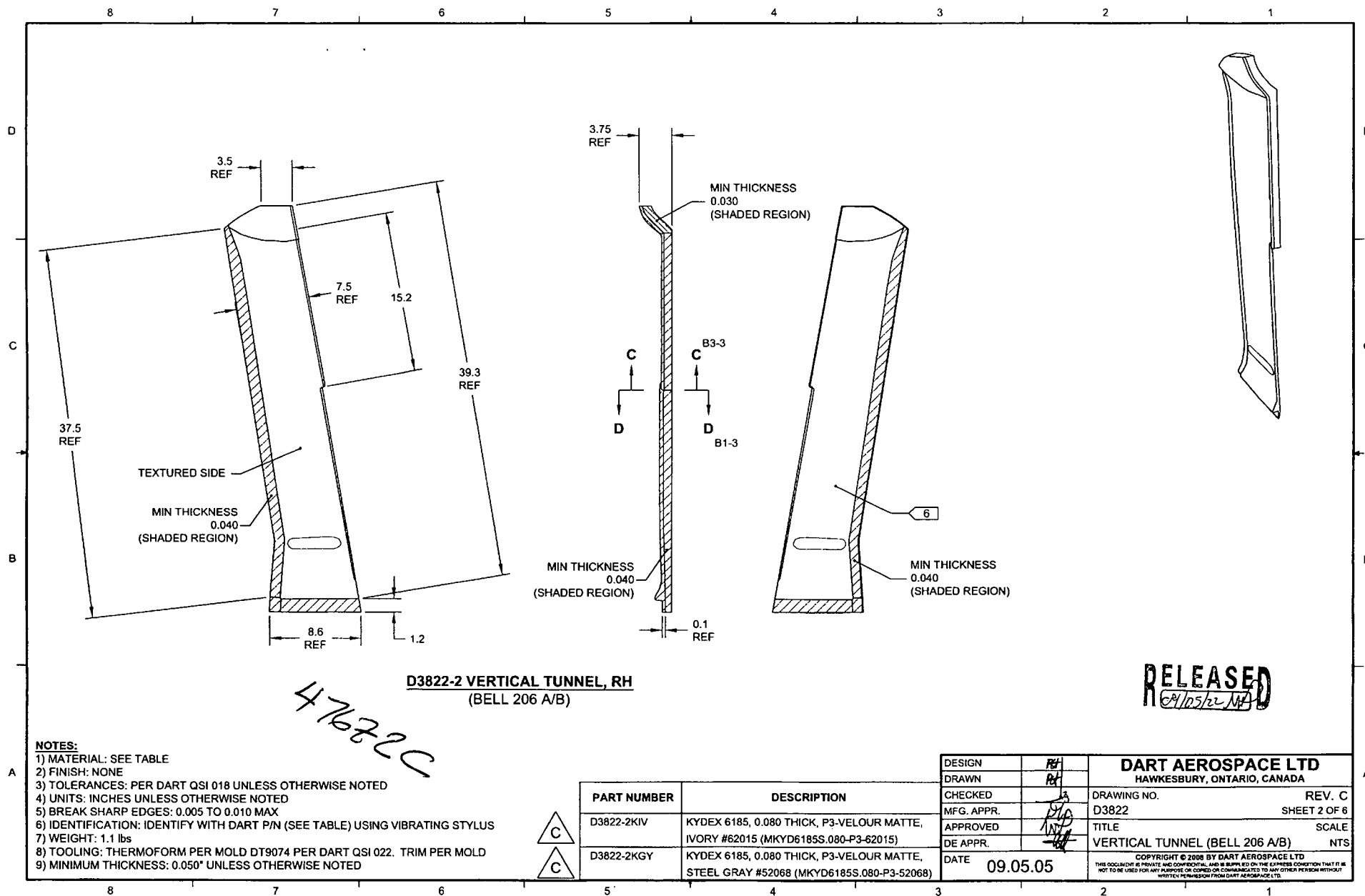
| | | | |
|--|----------|--|--------------|
| DESIGN | PA | DART AEROSPACE LTD | |
| DRAWN | PA | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PA | DRAWING NO. | REV. B |
| MFG. APPR. | PA | D3822 | SHEET 4 OF 6 |
| APPROVED | PA | TITLE | SCALE |
| DE APPR. | PA | VERTICAL TUNNEL (BELL 206 A/B) | NTS |
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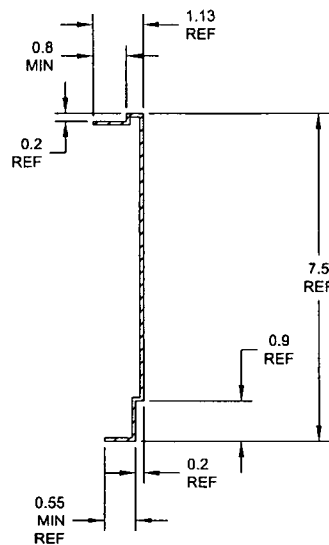
8 7 6 5 4 3 2 1





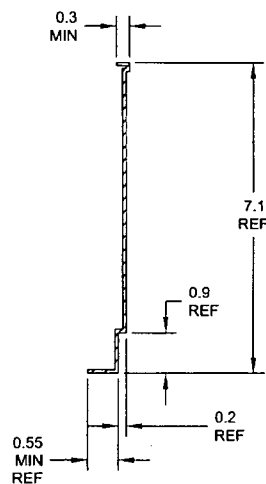






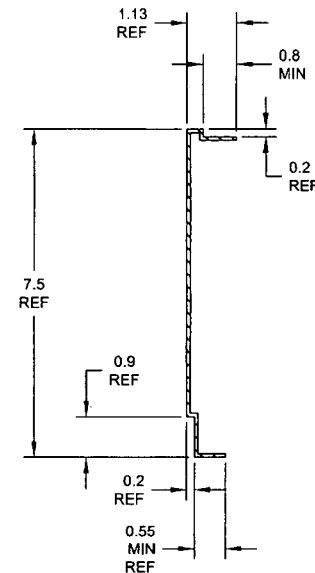
SECTION A-A

C6-1



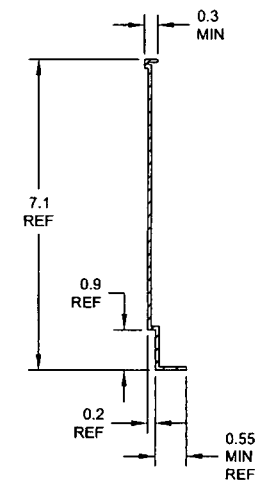
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

47672C

RELEASED
09/05/05

| | | | |
|------------|----------|---|--------------|
| DESIGN | RA | DART AEROSPACE LTD | |
| DRAWN | RA | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RA | DRAWING NO. | REV. C |
| MFG. APPR. | RA | D3822 | SHEET 3 OF 6 |
| APPROVED | RA | TITLE | SCALE |
| DE APPR. | RA | VERTICAL TUNNEL (BELL 206 A/B) | NTS |
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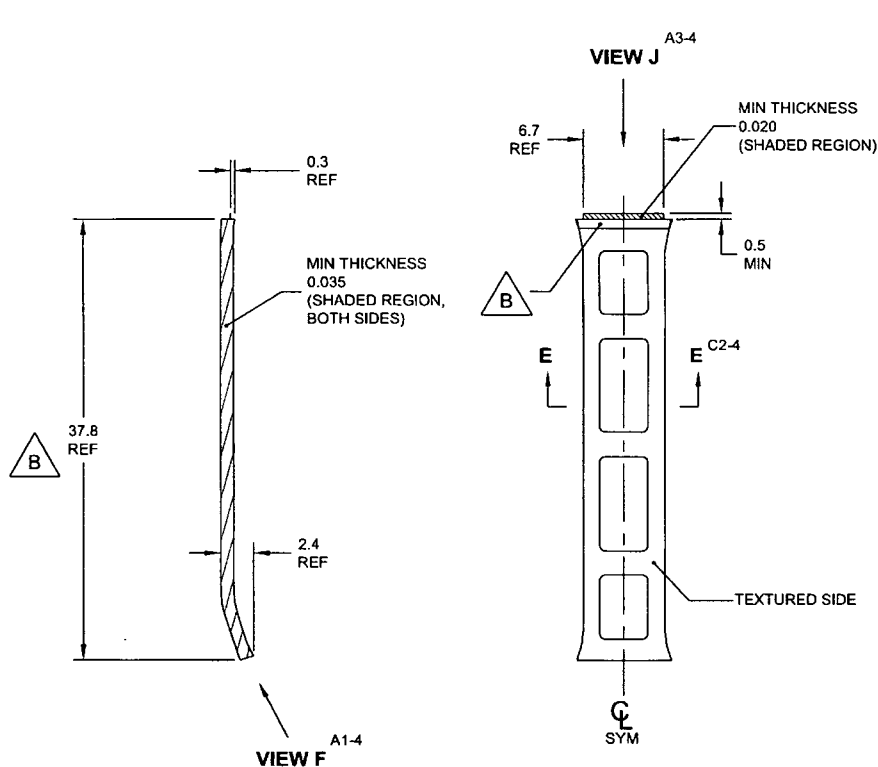
8 7 6 5 4 3 2 1

D

C

B

A

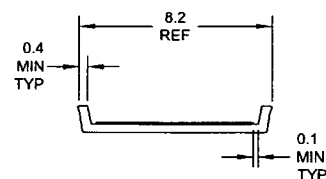


D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

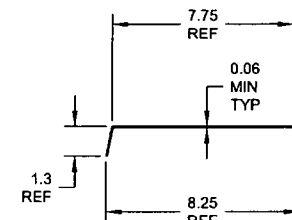
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3822-3KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3822-3KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |



VIEW J
SCALE 2X



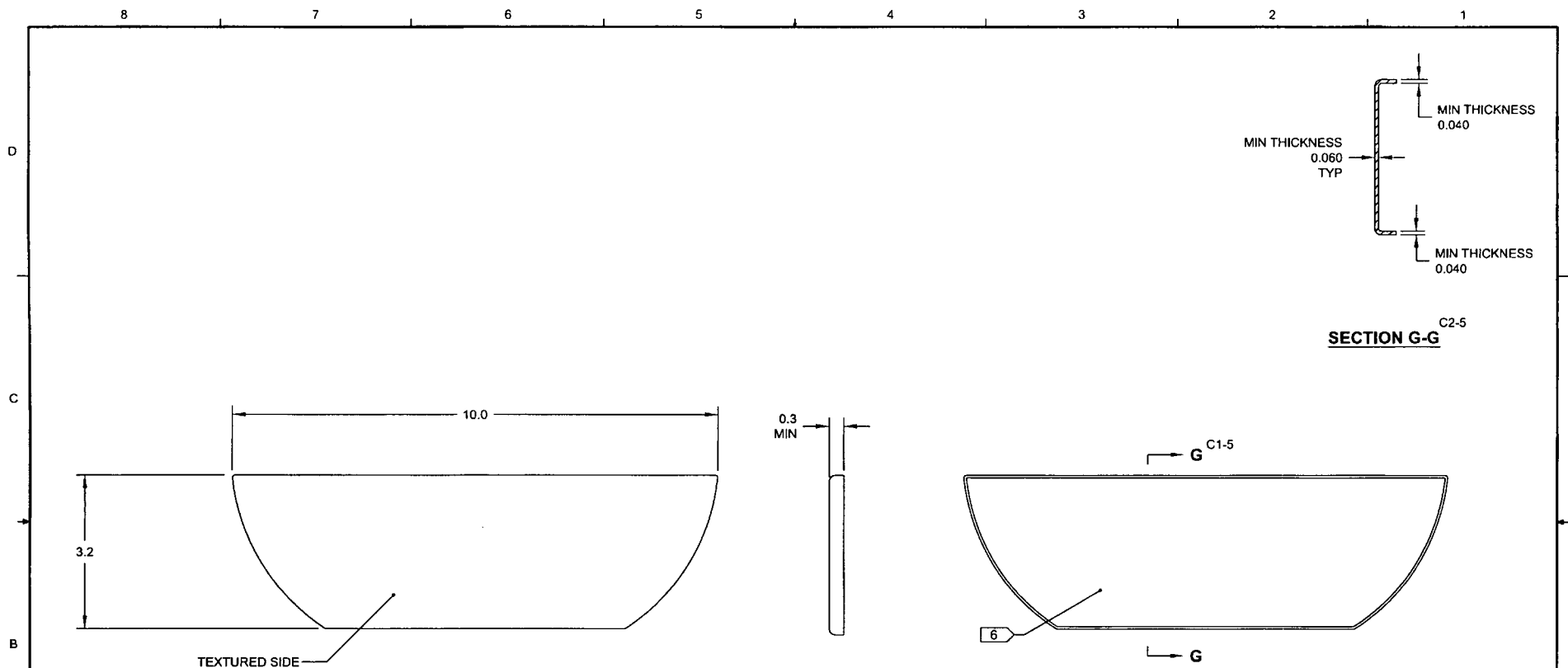
VIEW F
SCALE 2X
(ROTATED 90° CW)

RELEASED
09/05/22

| | |
|------------|--------------------------------|
| DESIGN | REV. C |
| DRAWN | D3822 |
| CHECKED | SHEET 4 OF 6 |
| MFG. APPR. | TITLE |
| APPROVED | VERTICAL TUNNEL (BELL 206 A/B) |
| DE APPR. | SCALE |
| DATE | 09.05.05 |
| | NTS |

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HAWKESBURY, ONTARIO, CANADA

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D3822-5 VERTICAL TUNNEL, TOP
(BELL 206 A/B)

RELEASED
9/25/02 M

NOTES:

- 1) MATERIAL: SEE TABLE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.12 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022



| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3822-5KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3822-5KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | | |
|--|--------------|--|--------------|
| DESIGN | <i>PH</i> | DART AEROSPACE LTD | |
| DRAWN | <i>PH</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>B</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>BS-10</i> | D3822 | SHEET 5 OF 6 |
| APPROVED | <i>PH</i> | TITLE | SCALE |
| DE APPR. | <i>PH</i> | VERTICAL TUNNEL (BELL 206 A/B) | NTS |
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